

Date: Monday, 7/9/2007 11:46:54 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	206/OH-58 SADDLE, INBOARD, RIGHT SIDE -UNDER REVIEW		
Job Number	33355			CB 07.07.10		
Estimate Number	10940					
P.O. Number	:			Part Number	D29381	
This Issue	7/9/2007	S.O. No.	:	Drawing Number	D2938 REV C	
Prsht Rev.	NC			Project Number	N/A	
First Issue	/ /	Type	MACHINED PARTS	Drawing Revision	C	
Previous Run	32381			Material	:	
Written By	<i>JL</i> 07.07.09			Due Date	7/30/2007	Qty: 20 Um: Each
Checked & Approved By						
Comment	Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	7075-T7351 2X6.25X7.875	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length (D6101-003)	B31387 <del>410578</del> 07/08/10 20
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 5-Deburr	<i>bml</i> 07/08/10 20
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	<i>bml</i> 07/08/10 20
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	<i>bml</i> 07/08/10 20

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:46:54 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER  
REVIEW

Job Number: 33355

Part Number: D29381

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*PF 07-08-10 20*

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*M 01 08 10*

*(20)*

7.0	POWDER COATING	POWDER COATING
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*M 10 50 68*



*(20X)*

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*M-p 07/08/11*

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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*C 07/08/13 (20)*



Comment: INSPECT POWDER COAT

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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*C 07/08/13 (20)*



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

*C 07/08/13 (20)*

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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*C 07/08/13 (20)*



Comment: FINAL INSPECTION/W/O RELEASE

*07.08.14*

Job Completion



*C 07/08/13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

X .005

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DART AEROSPACE LTD				Work Order:		33355
Description: 206 Saddle, Outboard, Left side				Part Number:		D2938-1
Inspection Dwg: D2938 Rev. C				Page 1 of 1		

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.129	0.133	.133	0.132		
B	0.100	0.140		0.130	0.132	.131	0.132		
C	0.100	0.140		0.118	0.115	.125	0.115		
D	0.210	0.230		0.223	0.223	.224	0.223		
E	1.245	1.255		1.250	1.250	1.250	1.249		
F	1.245	1.255		1.250	1.250	1.250	1.249		
G	2.495	2.505		2.499	2.499	2.499	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.578	1.577	1.577		
J	2.495	2.505		2.498	2.500	2.500	2.499		
K	0.257	0.262		0.258	0.258	.258	0.258		
L	0.312	0.317		0.314	.313	.313	0.314		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.119	0.119	.120	0.119		
O	0.540	0.560		0.550	0.552	.551	0.551		
P	0.490	0.510		0.506	.509	.504	0.505		
Q	3.715	3.725		3.719	3.718	3.720	3.718		
R	2.720	2.760		2.741	2.742	2.745	2.744		
S	0.240	0.270		0.257	0.254	.256	0.256		
T	0.100	0.180		0.135	0.146	.140	0.138		
U	1.625	1.635		1.628	1.628	1.629	1.628		
V	1.362	1.372		1.366	1.366	1.367	1.366		
W	0.316	0.321		0.320	0.326	.320	0.320		
X	1.250	1.270		1.258	1.260	1.260	1.259		
Y	1.565	1.585		1.573	1.573	1.574	1.573		
Z	0.178	0.198		0.188	0.188	.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>DK / SD</i>	Audited by:	<i>SC</i>
Date:	07/08/09	Date:	07-08-09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>JK</i>	<i>SPD</i>

DART AEROSPACE LTD				Work Order:	33358
Description: 206 Saddle, Outboard, Left side				Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.134	0.132	0.132	0.130		
B	0.100	0.140		0.131	0.132	0.134	0.134		
C	0.100	0.140		0.114	0.115	0.118	0.116		
D	0.210	0.230		0.224	0.223	0.223	0.224		
E	1.245	1.255		1.249	1.249	1.249	1.249		
F	1.245	1.255		1.249	1.250	1.250	1.250		
G	2.495	2.505		2.499	2.500	2.499	2.499		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.576	1.577	1.578		
J	2.495	2.505		2.500	2.499	2.499	2.499		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.237	0.238	0.238		
N	0.100	0.140		0.119	0.119	0.119	0.119		
O	0.540	0.560		0.550	0.556	0.556	0.556		
P	0.490	0.510		0.504	0.504	0.502	0.502		
Q	3.715	3.725		3.719	3.718	3.718	3.718		
R	2.720	2.760		2.742	2.742	2.743	2.743		
S	0.240	0.270		0.253	0.254	0.254	0.253		
T	0.100	0.180		0.137	0.138	0.138	0.138		
U	1.625	1.635		1.628	1.628	1.628	1.629		
V	1.362	1.372		1.366	1.367	1.366	1.366		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.250	1.270		1.260	1.260	1.259	1.259		
Y	1.565	1.585		1.574	1.573	1.573	1.574		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD / Chk	Audited by:	EC
Date:	07/08/09	Date:	07/08/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	SD

DART AEROSPACE LTD	Work Order:	33355
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.131	0.130	0.130	0.131		
B	0.100	0.140		0.132	0.131	0.132	0.133		
C	0.100	0.140		0.117	0.115	0.116	0.116		
D	0.210	0.230		0.224	0.225	0.224	0.224		
E	1.245	1.255		1.250	1.249	1.249	1.249		
F	1.245	1.255		1.250	1.256	1.249	1.249		
G	2.495	2.505		2.500	2.506	2.506	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.575	1.576	1.576	1.576		
J	2.495	2.505		2.506	2.499	2.499	2.499		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.237	0.238	0.238		
N	0.100	0.140		0.119	0.119	0.119	0.119		
O	0.540	0.560		0.556	0.550	0.550	0.550		
P	0.490	0.510		0.503	0.502	0.503	0.501		
Q	3.715	3.725		3.718	3.718	3.718	3.718		
R	2.720	2.760		2.744	2.743	2.741	2.742		
S	0.240	0.270		0.254	0.251	0.252	0.252		
T	0.100	0.180		0.135	0.135	0.140	0.146		
U	1.625	1.635		1.629	1.629	1.628	1.628		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.250	1.270		1.262	1.263	1.262	1.261		
Y	1.565	1.585		1.575	1.577	1.577	1.575		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>Onf</i>	Audited by:	<i>SG</i>
Date:	<i>07/08/09</i>	Date:	<i>07-08-10</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>JK</i>	<i>JLM</i>

DART AEROSPACE LTD				Work Order:	33355
Description: 206 Saddle, Outboard, Left side				Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.132	0.132	0.131	0.132		
B	0.100	0.140		0.130	0.132	0.132	0.133		
C	0.100	0.140		0.116	0.115	0.115	0.117		
D	0.210	0.230		0.224	0.224	0.223	0.224		
E	1.245	1.255		1.250	1.249	1.250	1.249		
F	1.245	1.255		1.250	1.250	1.250	1.249		
G	2.495	2.505		2.499	2.500	2.500	2.499		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.576	1.576	1.576		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.119	0.119	0.119	0.119		
O	0.540	0.560		0.550	0.550	0.550	0.550		
P	0.490	0.510		0.503	0.502	0.501	0.501		
Q	3.715	3.725		3.718	3.718	3.718	3.718		
R	2.720	2.760		2.743	2.742	2.743	2.744		
S	0.240	0.270		0.253	0.253	0.252	0.253		
T	0.100	0.180		0.136	0.135	0.138	0.138		
U	1.625	1.635		1.628	1.629	1.629	1.628		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.250	1.270		1.261	1.262	1.262	1.262		
Y	1.565	1.585		1.576	1.575	1.576	1.576		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	CMK	Audited by:	SK
Date:	07/08/10	Date:	07.08.10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	SK

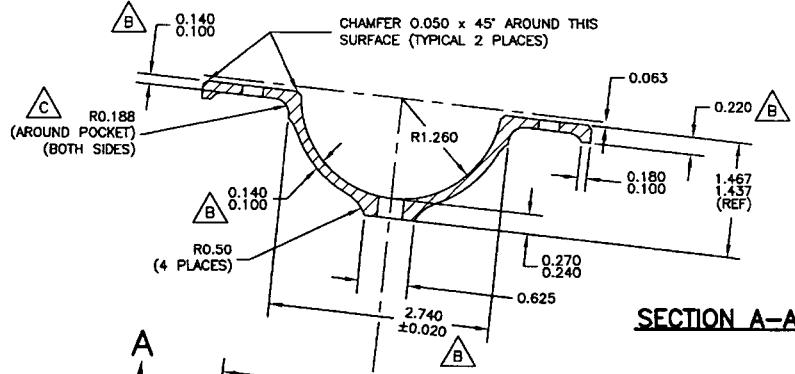
DART AEROSPACE LTD				Work Order: <u>33355</u>	
Description: 206 Saddle, Outboard, Left side				Part Number: <u>D2938-1</u>	
Inspection Dwg: D2938 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

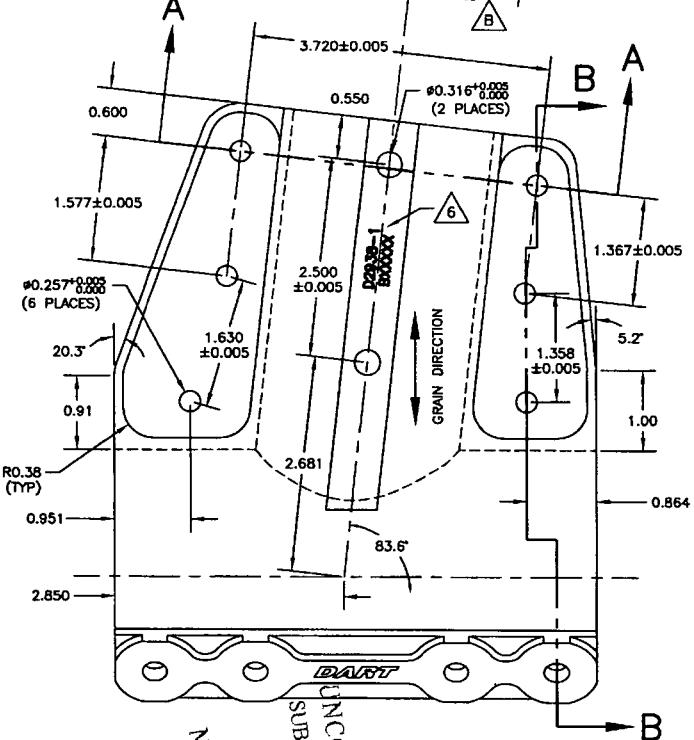
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.132	0.132	0.131	0.131		
B	0.100	0.140		0.134	0.134	0.133	0.134		
C	0.100	0.140		0.115	0.115	0.115	0.114		
D	0.210	0.230		0.224	0.225	0.224	0.224		
E	1.245	1.255		1.249	1.249	1.249	1.249		
F	1.245	1.255		1.249	1.249	1.250	1.249		
G	2.495	2.505		2.500	2.500	2.506	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.506	2.500	2.499	2.499		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.119	0.119	0.119	0.119		
O	0.540	0.560		0.550	0.551	0.551	0.550		
P	0.490	0.510		0.503	0.507	0.505	0.504		
Q	3.715	3.725		3.718	3.718	3.718	3.718		
R	2.720	2.760		2.743	2.743	2.743	2.743		
S	0.240	0.270		0.254	0.253	0.253	0.253		
T	0.100	0.180		0.141	0.138	0.137	0.138		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321		0.326	0.320	0.320	0.320		
X	1.250	1.270		1.260	1.260	1.261	1.261		
Y	1.565	1.585		1.574	1.576	1.576	1.575		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<u>JKL</u>	Audited by:	<u>BC</u>
Date:	07/08/10	Date:	07/08/10

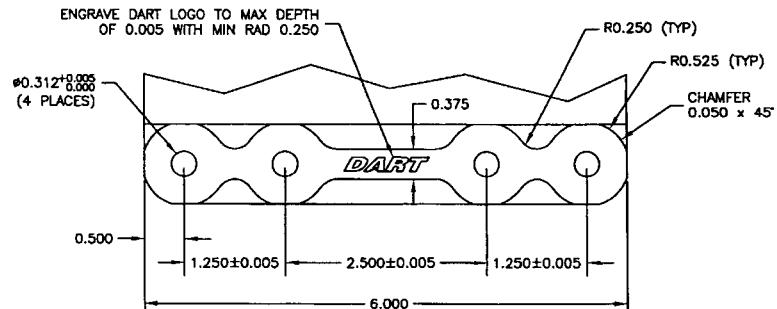
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<u>JL</u>



SECTION A-A



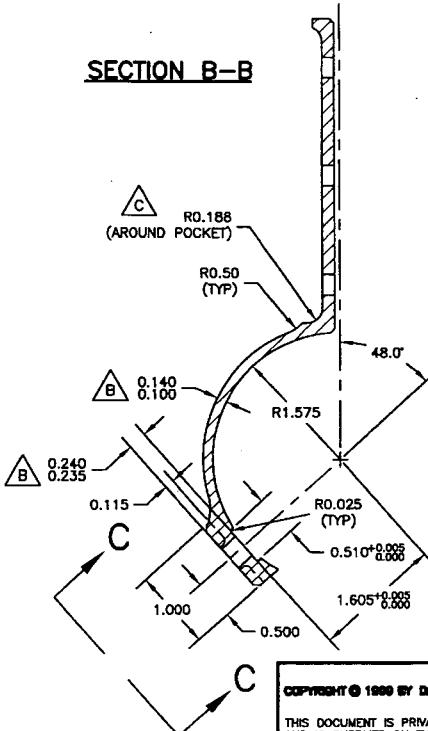
SECTION B-B



VIEW C-C

**D2938-1 LH SADDLE (SHOWN)**  
**D2938-2 RH SADDLE (OPPOSITE)**

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
  - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) ENgrave PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



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DART AEROSPACE USA, INC.

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA
06.11.09	CB	
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
WORK ORDER NO. 33355		
07-02-17		
SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE		
		DRAWING NO. D2938
		REV. C
		SHEET 1 OF 1
DATE		TITLE
06.11.09		SCALE 2:3 SADDLE OUTSIDE